

2011

SHIF JAN 6<sup>TH</sup>, 2017

**\*154336\***

**\*N900040100\***

**Setup Start \*NS1\***

Stop \*NS2\*

~~\*3\*~~ 4 ML5  
~~\*3\*~~

**Cust Item ID:**

**Customer:**

Run Start \*NR1\*

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D4039    | C            |

0.00

of Dict kit <sup>DAS</sup> **6** 9-89

## Memo

0.00

1- Assemble lanyard to bracket as per dwg

|                                               |      |
|-----------------------------------------------|------|
| QC5- Inspect part completeness to step on W/O | 0.00 |
|-----------------------------------------------|------|

0.00

## Memo

DAS  
38  
9-89  
JAN 19 2017

Identify as per dwg & Stock Location: 51476 0.00

1 DAS  
6  
9-89  
JAN 20 2017

## Memo

0.00

### Packaging

**Work Order ID 154336****\*154336\***

Page 2

Thursday, December 08, 2016 4:03:15 PM

Item ID: D4039-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Fwd Bracket Assembly

Start Date: 12/12/2016 Start Qty: 3.00

**\*3\***

Cust Item ID:

Required Date: 1/3/2017 Req'd Qty: 3.00

**\*3\***

Customer:

Reference:

Run Start **\*NR1\***

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

**\*130\***

QC

Memo

0.00

Quality Control

DAS  
21  
9-89

JAN 23 2017

JAN 20 2017

# Picklist Print

Page 1

Thursday, December 08, 2016 4:03:27 PM

Work Order ID: 154336

\*154336\*

Parent Item: D4039-041

\*D4039-041\*

Parent Item Name: Fwd Bracket Assembly

Start Date: 12/12/2016

Required Date: 1/3/2017

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: new issue DD 09.12.15 verified by:EC  
B:AS PER ECN 10-563 10-09-28 JLM VERIFIED BY:DD

IPP REV

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty    | Qty<br>Issued    | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|-----------------|------------------|----------------|--------|
| MS17984-C416                    |                        | Purchased     | No          |                     |                  |                 | Each               | 4.0000         |             | 34              | DAS<br>6<br>9-89 | JAN 05 2017    |        |
| *MS17984-C416*                  |                        |               |             |                     |                  |                 |                    |                |             |                 |                  |                |        |
| Quick Release Pin               |                        |               |             |                     |                  |                 |                    |                |             |                 |                  |                |        |
|                                 |                        |               |             | <u>Location</u>     |                  |                 |                    | <u>Loc Qty</u> |             | <u>Loc Code</u> |                  |                |        |
|                                 |                        |               |             | over005             |                  |                 |                    | 4              |             |                 |                  |                |        |
|                                 |                        |               |             | m136089             |                  |                 |                    | 4              |             |                 |                  |                |        |
| D4039-1                         |                        | Manufactured  | No          |                     |                  | 100             | Each               | 0.0000         | 1           | 34              | DAS<br>6<br>9-89 | JAN 05 2017    |        |
| *D4039-1*                       |                        |               |             |                     |                  |                 |                    |                |             |                 |                  |                |        |
| Fwd Bracket                     |                        |               |             |                     |                  |                 |                    |                |             |                 |                  |                |        |
| D2690-6                         |                        | Manufactured  | No          |                     |                  | 100             | Each               | 11.0000        | 1           | 34              | DAS<br>6<br>9-89 | JAN 05 2017    |        |
| *D2690-6*                       |                        |               |             |                     |                  |                 |                    |                |             |                 |                  |                |        |
| Lanyard                         |                        |               |             |                     |                  |                 |                    |                |             |                 |                  |                |        |
|                                 |                        |               |             | <u>Location</u>     |                  |                 |                    | <u>Loc Qty</u> |             | <u>Loc Code</u> |                  |                |        |
|                                 |                        |               |             | ST009               |                  |                 |                    | 11             |             |                 |                  |                |        |
|                                 |                        |               |             | 151983              |                  |                 |                    | 11             |             |                 |                  |                |        |
| MS27039-1-11                    |                        | Purchased     | No          |                     |                  | 100             | Each               | 125.0000       | 1           | 34              | DAS<br>6<br>9-89 | JAN 05 2017    |        |
| *MS27039-1-11*                  |                        |               |             |                     |                  |                 |                    |                |             |                 |                  |                |        |
| Screw                           |                        |               |             |                     |                  |                 |                    |                |             |                 |                  |                |        |
|                                 |                        |               |             | <u>Location</u>     |                  |                 |                    | <u>Loc Qty</u> |             | <u>Loc Code</u> |                  |                |        |
|                                 |                        |               |             | GA                  |                  |                 |                    | 8              |             |                 |                  |                |        |
|                                 |                        |               |             | 9662                |                  |                 |                    | 8              |             |                 |                  |                |        |
|                                 |                        |               |             | ST280               |                  |                 |                    | 117            |             |                 |                  |                |        |
|                                 |                        |               |             | m134738             |                  |                 |                    | 17             |             |                 |                  |                |        |
|                                 |                        |               |             | m135978             |                  |                 |                    | 100            |             |                 |                  |                |        |

M136579 ①

136442

157339

152878x3

4

34

4

# Picklist Print

Thursday, December 08, 2016 4:03:27 PM

Work Order ID: 154336

**\*154336\***

Parent Item: D4039-041

**\*D4039-041\***

Parent Item Name: Fwd Bracket Assembly

Start Date: 12/12/2016

Required Date: 1/3/2017

Start Qty: 3.00

Required Qty: 3.00

MS21042L3

Purchased

No

100

Each

1,745.000

1

**\*\***

DAS

6

9-89

JAN 05 2017

**\*MS21042L3\***

Nut

Location

Loc Qty

Loc Code

CCK007

600

M136192

600

FP001

100

m135945

100

GA

176

m134360

108

m135135

68

ST303

869

m135945

269

M136044

600

100

Each

1,617.000

3

**\*\***

DAS

6

9-89

JAN 05 2017

NAS1149D0363J

Purchased

No

**\*NAS1149D0363J\***

Washer

Location

Loc Qty

Loc Code

GA

332

m134055

332

ST260a

1000

m136318

1000

ST263

285

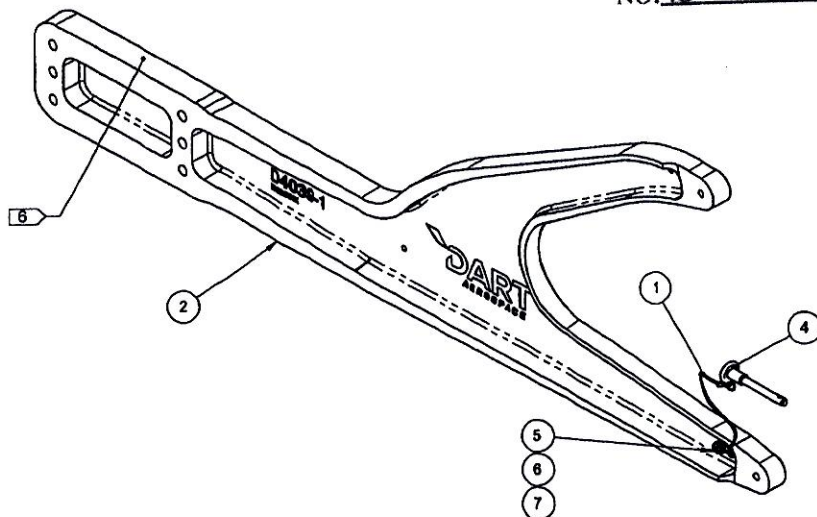
m135864

285

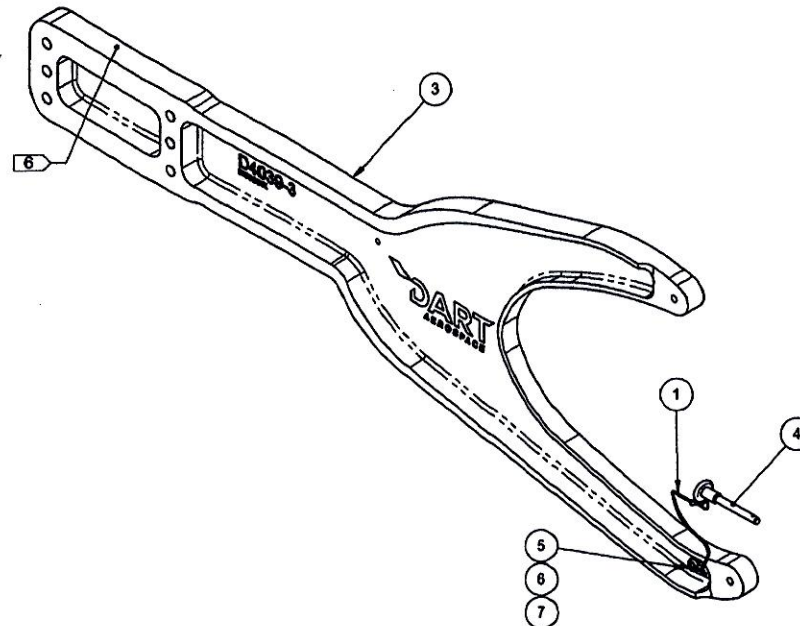


| ITEM | QTY -041 | QTY -043 | P/N           | DESCRIPTION          |
|------|----------|----------|---------------|----------------------|
|      | X        |          | D4039-041     | FWD BRACKET ASSEMBLY |
|      |          | X        | D4039-043     | AFT BRACKET ASSEMBLY |
| 1    | 1        | 1        | D2890-6       | LANYARD              |
| 2    | 1        |          | D4039-1       | FWD BRACKET          |
| 3    |          | 1        | D4039-3       | AFT BRACKET          |
| 4    | 1        | 1        | MS17984-C416  | PIN, QUICK RELEASE   |
| 5    | 1        | 1        | MS27039-1-11  | SCREW, PAN-HEAD      |
| 6    | 1        | 1        | MS21042L3     | NUT, SELF-LOCKING    |
| 7    | 3        | 3        | NAS1149D0363J | WASHER               |

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 15436



**D4039-041 FWD BRACKET ASSEMBLY**



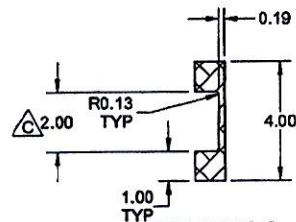
**D4039-043 AFT BRACKET ASSEMBLY**

**RELEASED**

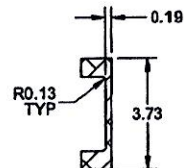
2016 NOV 02  
EON 16-513 4P

- NOTES:  
1) MATERIAL: N/A  
2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: N/A  
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1  
7) WEIGHT: N/A

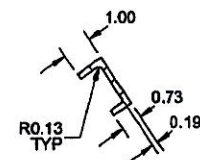
|            |                                                                                                        |                                                                                                                                                                                                                                                                      |          |
|------------|--------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|
| REV.       | DESCRIPTION                                                                                            | BY                                                                                                                                                                                                                                                                   | DATE     |
| C          | REVISE DESIGN OF -1 AND -3 BRACKETS: ZN C4-2, B4-2, C4-3, B4-3, REVISE NOTES 7 AND 8; A6-2, A8-3, B5-1 | VS                                                                                                                                                                                                                                                                   | 15.11.05 |
| B          | REVISE HOLE SIZE ON D4039-3 FROM 0.181 TO 0.203, ZN B6-3                                               | VS                                                                                                                                                                                                                                                                   | 10.04.28 |
| A          | NEW ISSUE                                                                                              | HS                                                                                                                                                                                                                                                                   | 09.12.14 |
| DESIGN     | VS                                                                                                     | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA<br>DRAWING NO. <b>D4039</b><br>TITLE <b>BRACKET</b><br>SCALE <b>NTS</b>                                                                                                                                     |          |
| DRAWN      | VS                                                                                                     |                                                                                                                                                                                                                                                                      |          |
| CHECKED    | RF                                                                                                     |                                                                                                                                                                                                                                                                      |          |
| MFG. APPR. | JFS                                                                                                    |                                                                                                                                                                                                                                                                      |          |
| DE APPR.   | DS                                                                                                     |                                                                                                                                                                                                                                                                      |          |
| DATE       | 15.11.05                                                                                               | COPYRIGHT © 2009 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE EXPRESS PERMISSION FROM DART AEROSPACE LTD. |          |



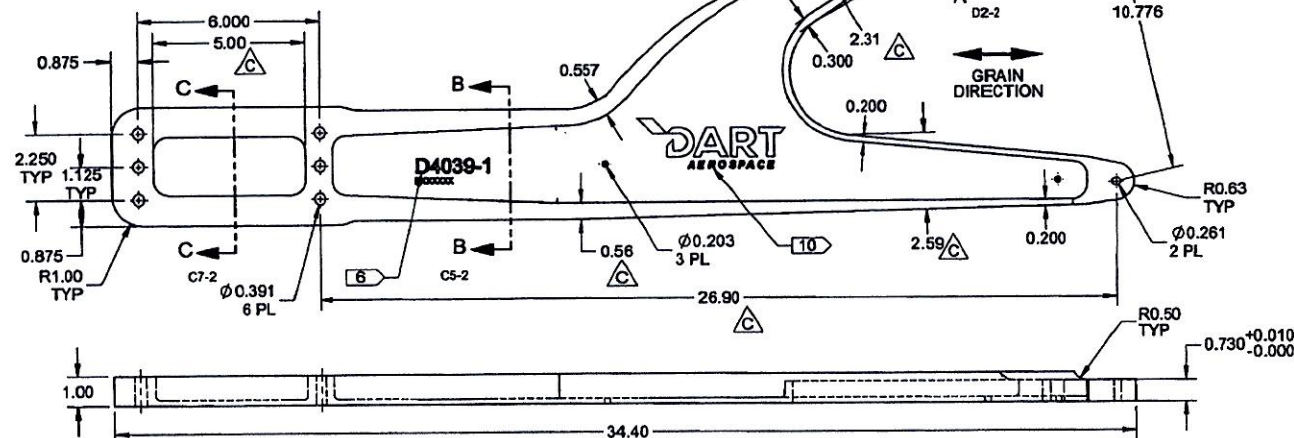
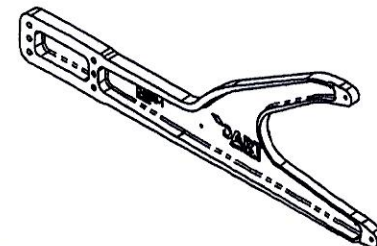
SECTION C-C  
B7-2



SECTION B-B  
B6-2



SECTION A-A  
C4-2



D4039-1 FWD BRACKET

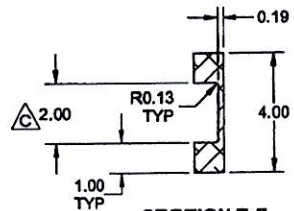
NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 1.000 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC M6061T6S1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AND B/N IN THIS AREA TO MAX  
DEPTH OF 0.010 WITH MIN TOOL RADIUS OF 0.010 PER QSI 044 6.3
- 7) WEIGHT: 6.60 lbs
- 8) MACHINE PER DART SOLIDWORKS PART "D4039-1.SLDPRT" AT REV. C
- 9) UNDEFINED FEATURES CONTROLLED BY SOLIDWORKS PART "D4039-1.SLDPRT" AT REV. C
- 10) ENGRAVE DART LOGO IN THIS AREA TO MAX DEPTH OF 0.015 WITH MIN TOOL RADIUS OF 0.250

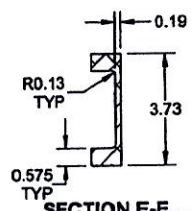
RELEASED

2016 NOV 02

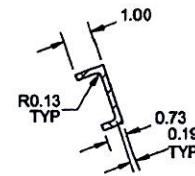
|          |            |          |                                                                                                                                                                                                                                                                                                  |              |
|----------|------------|----------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| APPROVED | DESIGN     | VS       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                         |              |
|          | DRAWN      | VS       |                                                                                                                                                                                                                                                                                                  |              |
|          | CHECKED    | RF       | DRAWING NO.                                                                                                                                                                                                                                                                                      | REV. C       |
|          | MFG. APPR. | JFS      | D4039                                                                                                                                                                                                                                                                                            | SHEET 2 OF 3 |
|          | APPROVED   | HS       | TITLE                                                                                                                                                                                                                                                                                            | SCALE        |
|          | DE APPR.   | DS       | BRACKET                                                                                                                                                                                                                                                                                          | NTS          |
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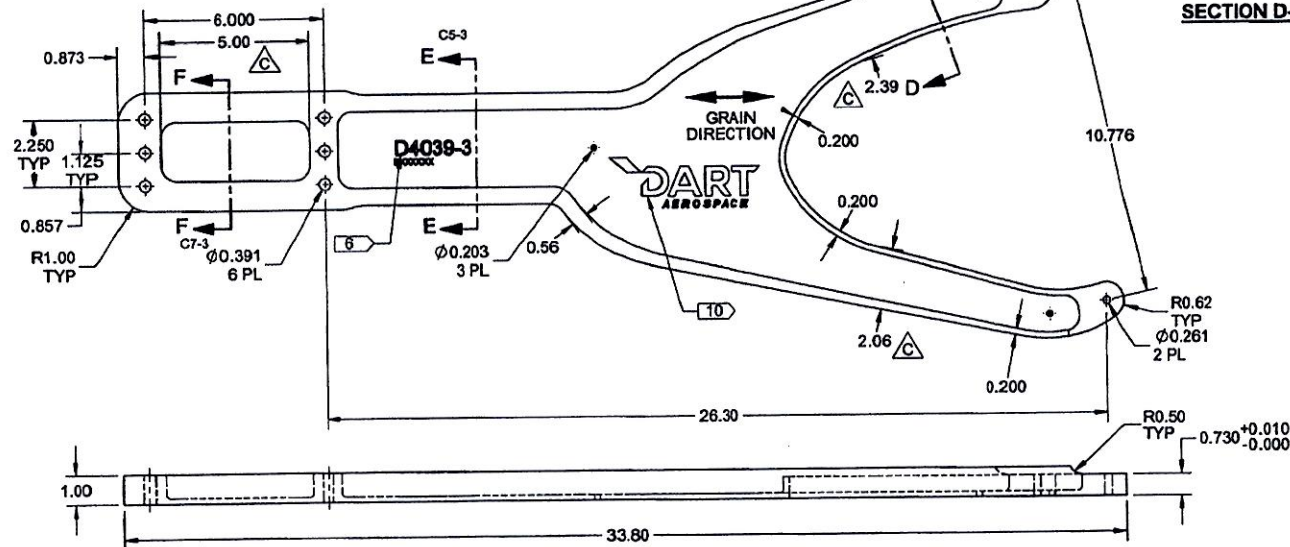
SECTION F-F  
C7-3



SECTION E-E  
C6-3



SECTION D-D  
C4-3



D4039-3 AFT BRACKET

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 1.000 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC M6061T6S1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AND B/N IN THIS AREA TO MAX  
DEPTH OF 0.010 WITH MIN TOOL RADIUS OF 0.010 PER QSI 044 6.3
- 7) WEIGHT: 6.40 lbs
- 8) MACHINE PER DART SOLIDWORKS PART "D4039-3.SLDPRT" AT REV. C
- 9) UNDEFINED FEATURES CONTROLLED BY SOLIDWORKS PART "D4039-3.SLDPRT" AT REV. C
- 10) ENGRAVE DART LOGO IN THIS AREA TO MAX DEPTH OF 0.015 WITH MIN TOOL RADIUS OF 0.250

APPROVED

|            |          |                                                                                                                                                                                                                                                                                |              |
|------------|----------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | VS       | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                              |              |
| DRAWN      | VS       |                                                                                                                                                                                                                                                                                |              |
| CHECKED    | RF       | DRAWING NO.                                                                                                                                                                                                                                                                    | REV. C       |
| MFG. APPR. | JFS      | D4039                                                                                                                                                                                                                                                                          | SHEET 3 OF 3 |
| APPROVED   | HS       | TITLE                                                                                                                                                                                                                                                                          | SCALE        |
| DE APPR.   | DS       | BRACKET                                                                                                                                                                                                                                                                        | NTS          |
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